

Work Order ID 111609

January-15-14 1:19:33 PM

111609

Page 1

Item ID: D2739 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 350 I Beam
 Start Date: 1/15/14 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 1/24/14 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 14-01-17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2739	Rev E

100

0.00

100

Skidtubes

Skidtubes

Skidtubes

Memo

0.00

- 1-Cut D2600-5 to length as per Dwg D2739. 14-01-20 D6C
- 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 14-01-21
- 3-Use uni-bit to open holes to finish size as per Dwg D2739.
- 4-Bevel Fwd end of extrusion and Deburr holes and ends.
- 5-Deburr

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Hand Finishing

Memo

0.00

10 14-01-21 D6C
14-01-21
14-01-23 CR
PTO

DQA:

Date: 14/2/10

WORK ORDER NON-CONFORMANCE / UPDATE

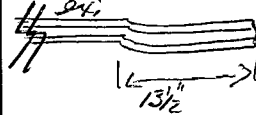


QA Closed: 14/1/31

Date: 14-1-31

Work Order update only ☐

Work Order: <u>111609</u>	DISPOSITION Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input checked="" type="checkbox"/>	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D2739</u>		Skid-tube <input checked="" type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>
NCR No. <u>14-3473</u>		Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>
		Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>
		Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	14-1-23	120	1	While abiding employee noticed that extension was deformed on ridge side  Re Drawn	DAS 16 9-89 Q32043 14/1/23	Scrap, NO replace. 34.67.	14-1-28 Dd	14-1-28	DAS 16 9-89 Q32042 14/1/28
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General		
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Folio/Program	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Centre Not Concentric	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Grain	<input type="checkbox"/> Pressure/Forced
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damage/Defect	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance
<input type="checkbox"/> Crimp/Kink/Ripple/Wave	<input type="checkbox"/> Burrs	<input type="checkbox"/> Inspection Incomplete/Unqualified	<input type="checkbox"/> Part Incorrect
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing
<input type="checkbox"/> Crushing	<input type="checkbox"/> Countersink	<input type="checkbox"/> Misaligned/off center	<input type="checkbox"/> Part Moved
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Drawing	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge
<input type="checkbox"/> Marks/Chatter	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Off-set	<input type="checkbox"/> Wrong Stock Pulled
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Other
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Fit/Function	<input type="checkbox"/> Out of Sequence	

Work Order ID 111609

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111609

Page 2

Item ID: D2739 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: 350 I Beam
Start Date: 1/15/14 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 1/24/14 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC5- Inspect part completeness to step on W/O	0.00							
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130

QC

Quality Control

Memo

0.00

140

Identify as per dwg & Stock Location: 46

0.00

140

Packaging

Packaging

Memo

0.00

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Quality Control

Memo

0.00

DP 14-1-28 (9)

DP 14-1-28 (9)

MLJ 14-01-29
DP 14-01-28

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Picklist Print

January-15-14 1:19:32 PM

Page 1

Work Order ID: 111609
Parent Item: D2739
Parent Item Name: 350 I Beam

Start Date: 1/15/14

Required Date: 1/24/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev: C02.11.28ReformatKJ
IPP Rev: D 06-03-21 As Per Rev C JLM
IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev:F 10.11.02 as per revE
DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-5-108 Extrusion 'I Beam' thin		Manufactured	No				Each	76.0000		10			

Location

Loc Qty

Loc Code

HALL

76

105417

76

10

1/01-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

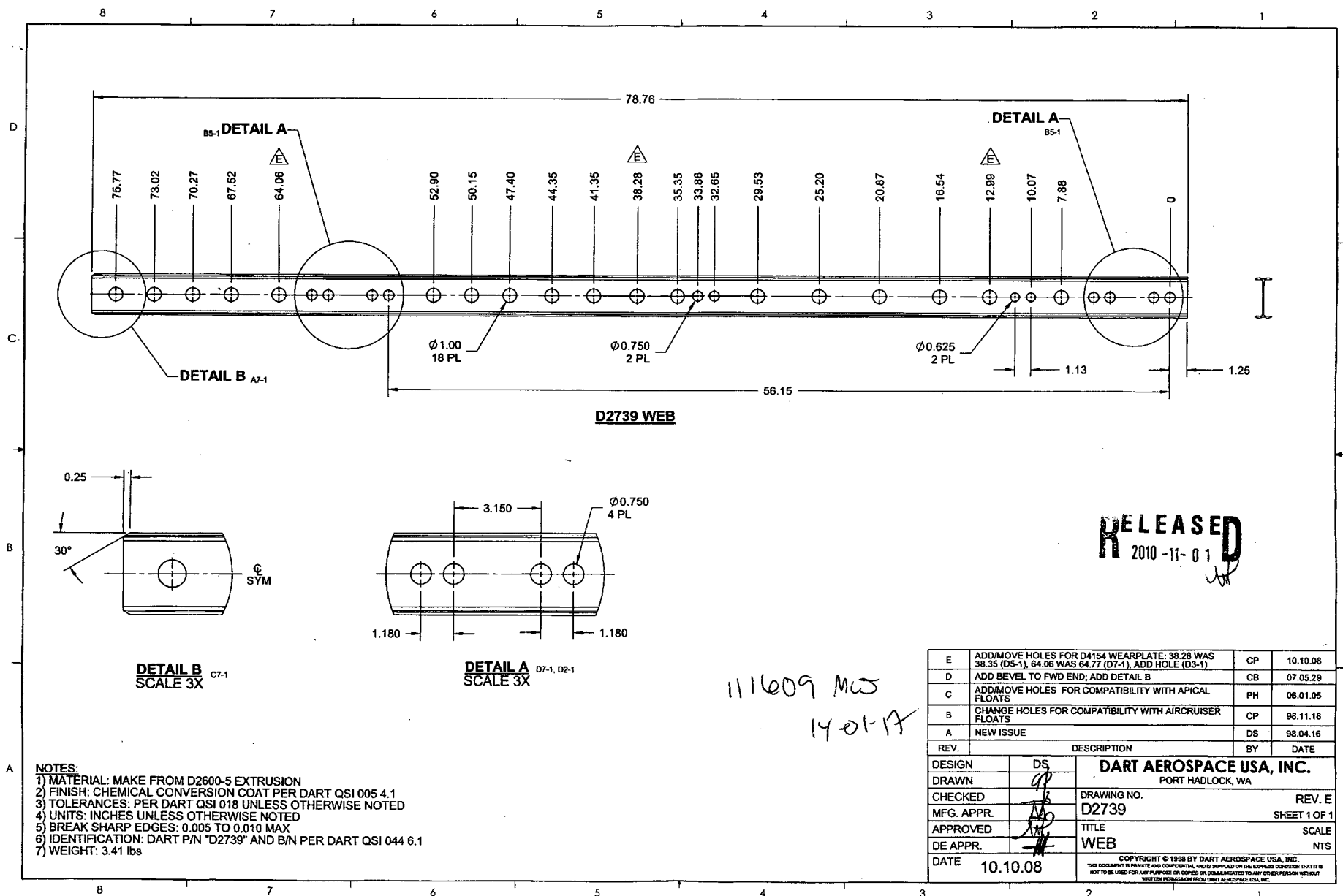
Work Order update only ☐

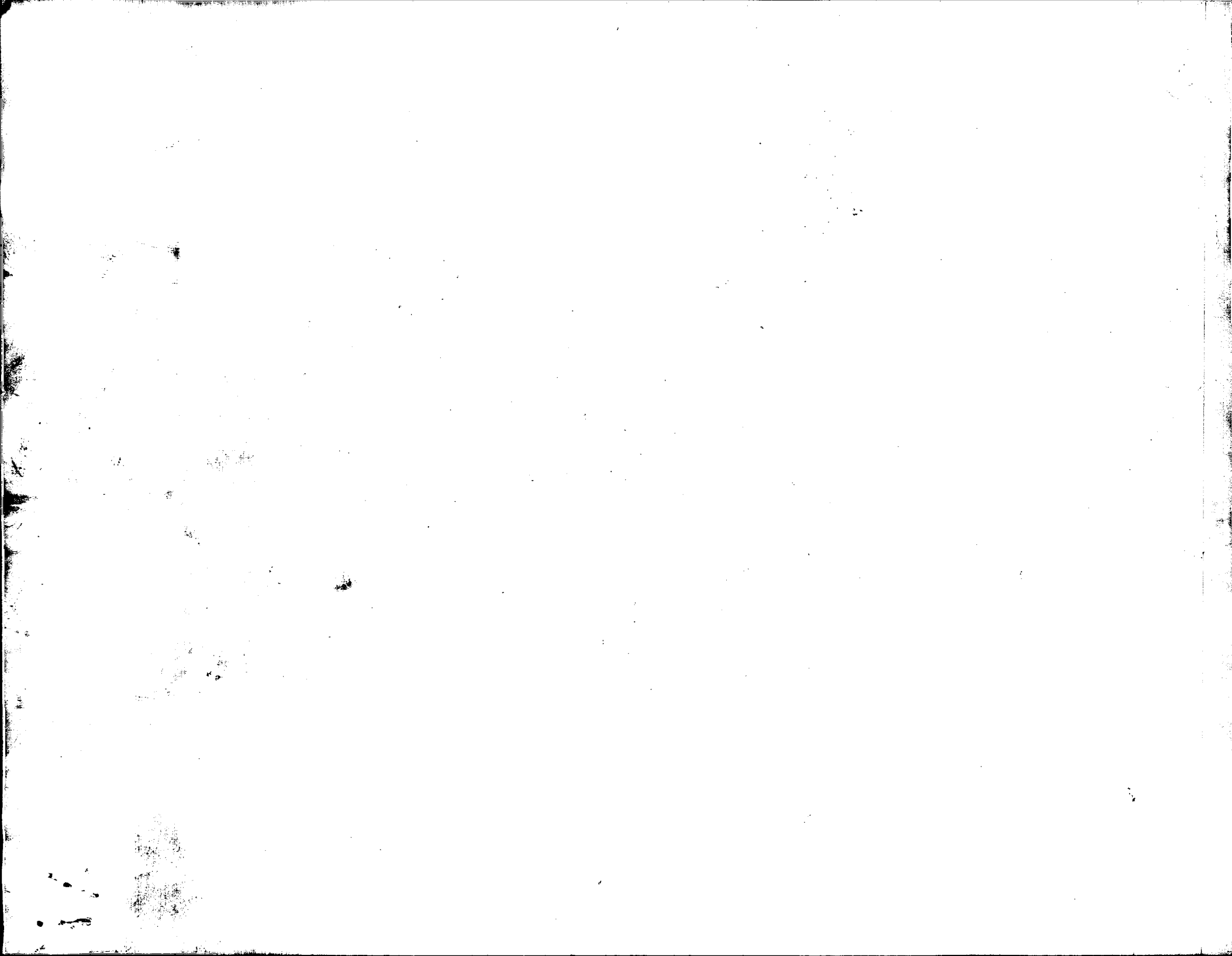
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DART AEROSPACE LTD		Work Order: 111609
Description: 350 I-Beam		Part Number: A2239
Inspection Dwg: A2239, Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.25	+/- 0.030	1.25	✓			
1.13	+/- 0.030	1.13	✓			
56.15	+/- 0.030	56.15	✓			
7.88	+/- 0.030	7.87	✓			
10.07	+/- 0.030	10.06	✓			
12.99	+/- 0.030	12.99	✓			
16.54	+/- 0.030	16.54	✓			
20.87	+/- 0.030	20.85	✓			
25.20	+/- 0.030	25.20	✓			
29.53	+/- 0.030	29.53	✓			
32.65	+/- 0.030	32.63	✓			
33.86	+/- 0.030	33.86	✓			
35.35	+/- 0.030	35.35	✓			
38.28	+/- 0.030	38.22	✓			
41.35	+/- 0.030	41.35	✓			
44.35	+/- 0.030	44.35	✓			
47.40	+/- 0.030	47.39	✓			
50.15	+/- 0.030	50.15	✓			
52.90	+/- 0.030	52.90	✓			
64.06	+/- 0.030	64.06	✓			
67.52	+/- 0.030	67.52	✓			
70.27	+/- 0.030	70.25	✓			
73.02	+/- 0.030	73.02	✓			
75.77	+/- 0.030	75.76	✓			

Measured by: DGL
Date: 14-01-21

Audited by: [Signature]
Date: 14-1-21

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	